

FIG.1

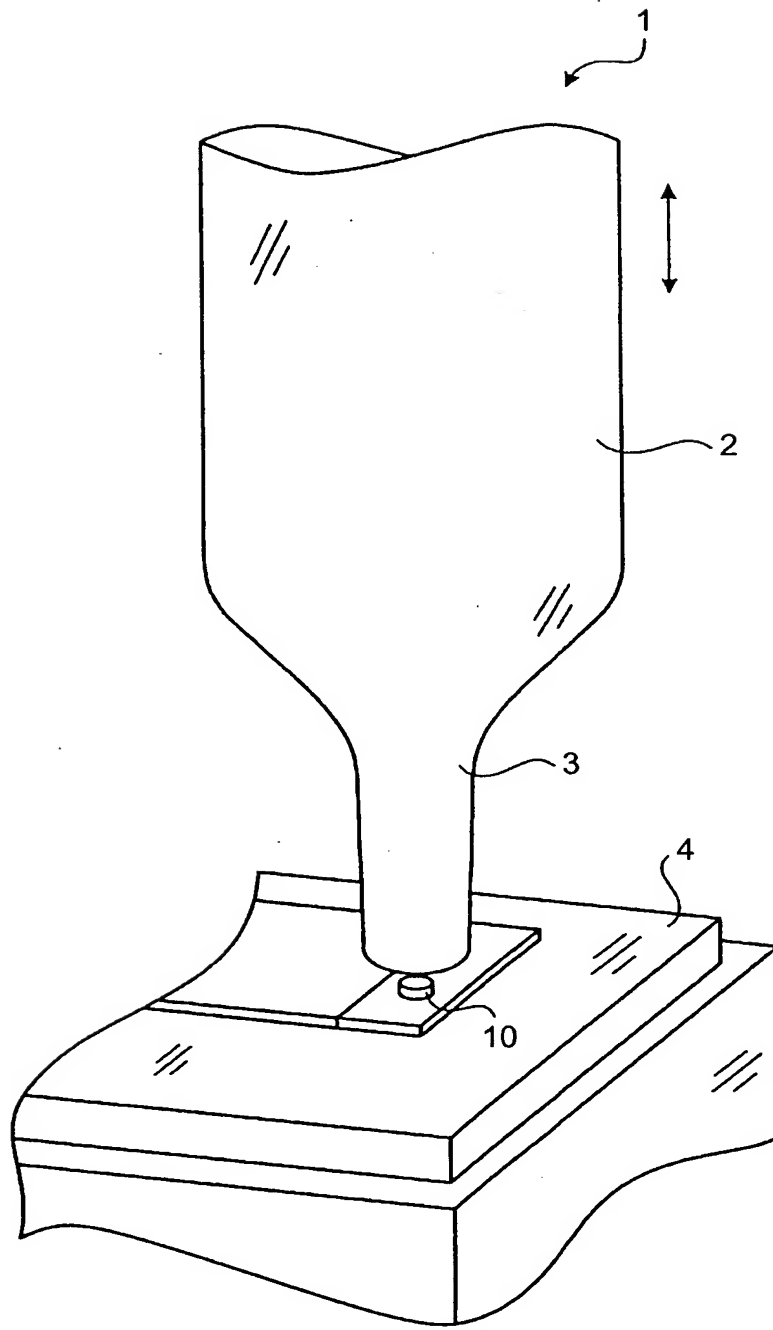


FIG.2

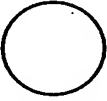
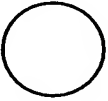
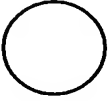
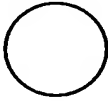
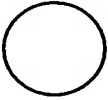
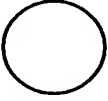
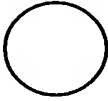
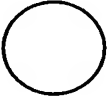
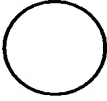
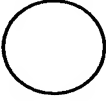
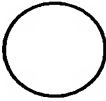
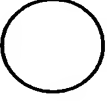
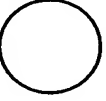
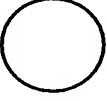
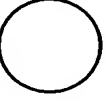
EFFECTS MEASURES	REDUCTION OF ENERGY APPLIED	REDUCTION OF DEFORMATION OF MOLTEN RESIN	IMPROVEMENT IN DEFORMATION DIRECTION OF MOLTEN RESIN	RELAXATION AND HOMOGENIZATION OF INTERNAL STRESS	REDUCTION OF SENSITIVITY TO POSITIONING ERROR
ENLARGE DIAMETER OF BOTTOM OF RESIN					
PROVIDE CONCAVE PORTION IN CENTER OF RESIN					
INCLINE HORN					
PROVIDE R-SHAPED INLET OF HOLE OF RESIN					
PERFORM HEATING OF HORN					
PROVIDE HIGH FREQUENCY ULTRASONIC WAVE					

FIG.3

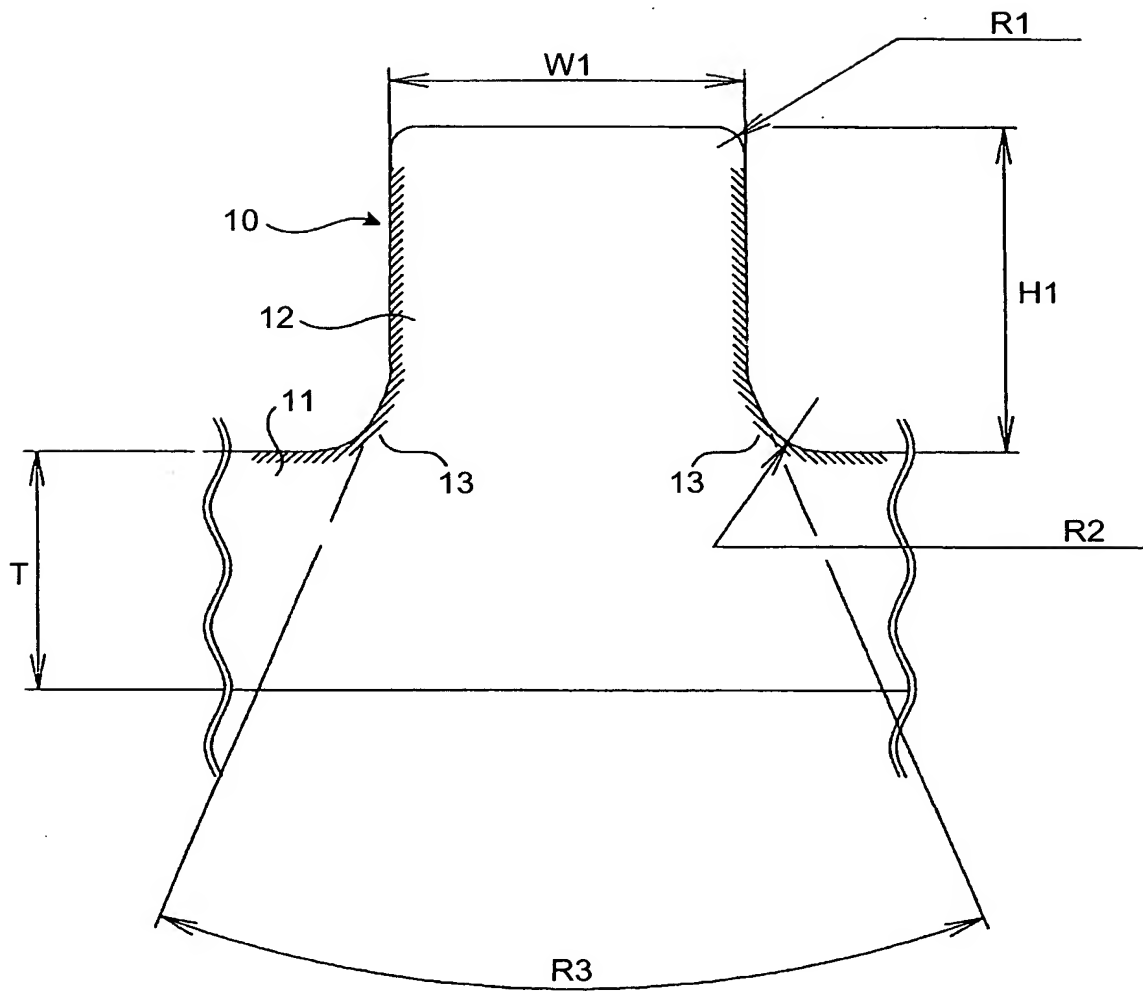


FIG.4

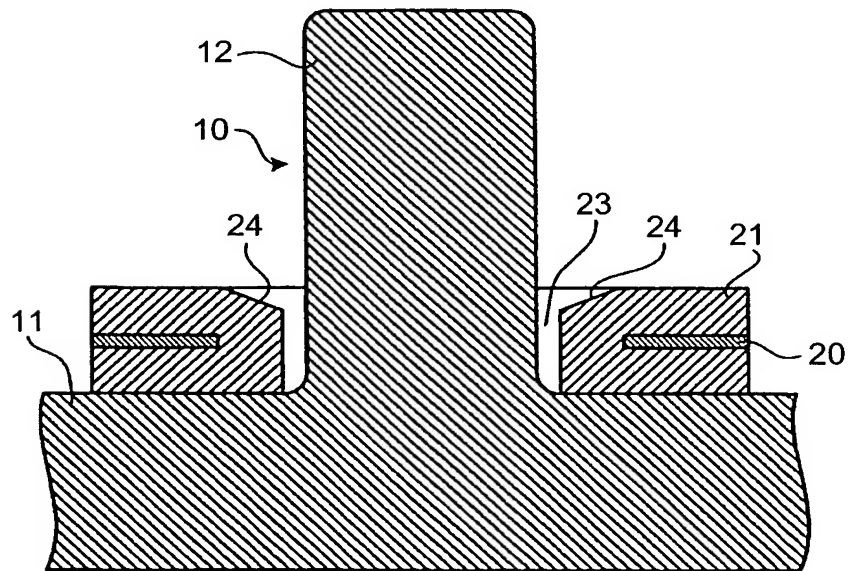
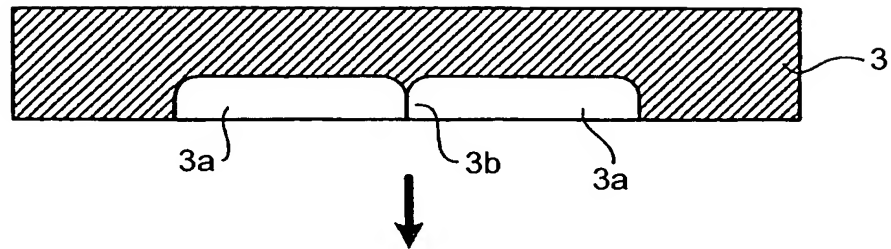


FIG.5

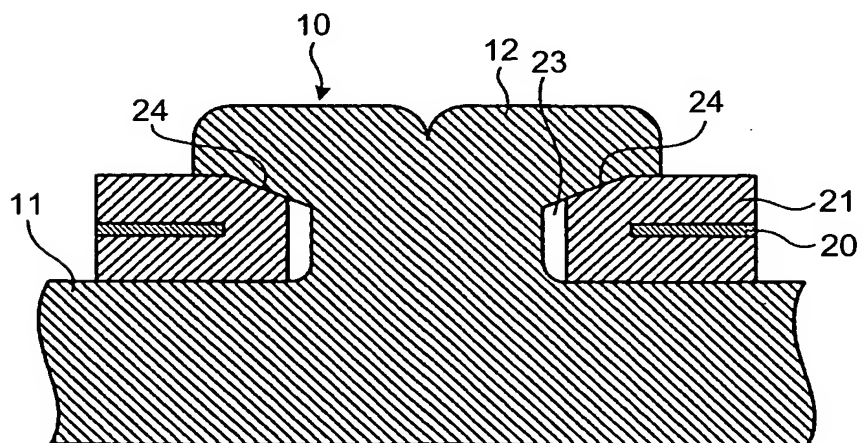


FIG.6

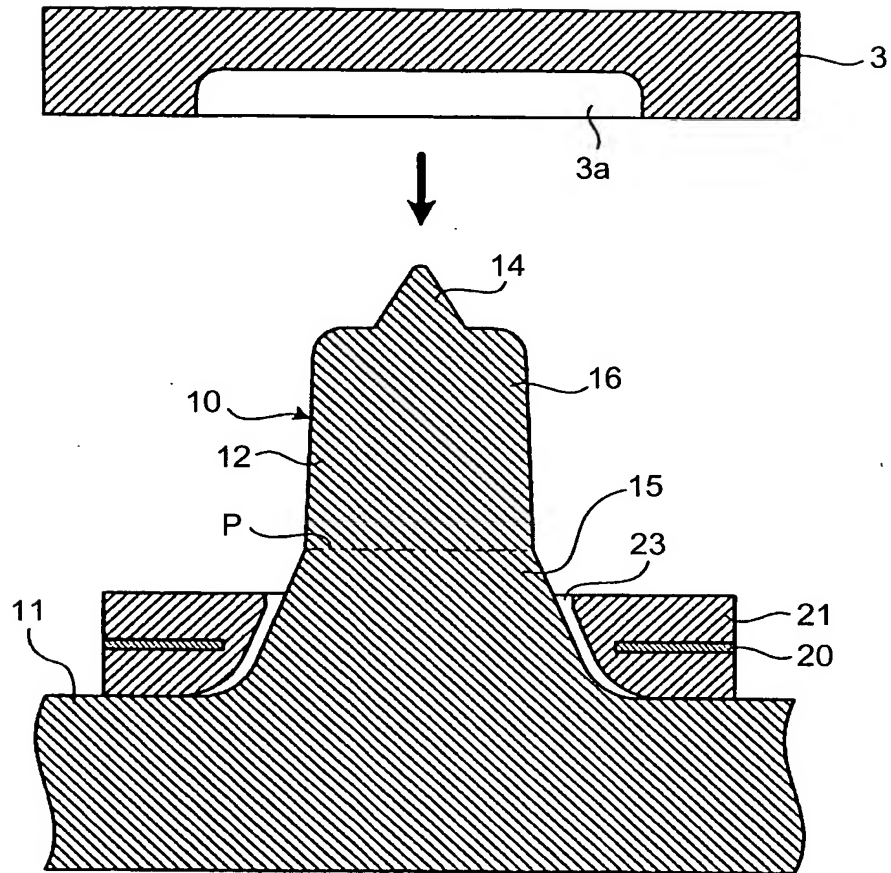


FIG.7

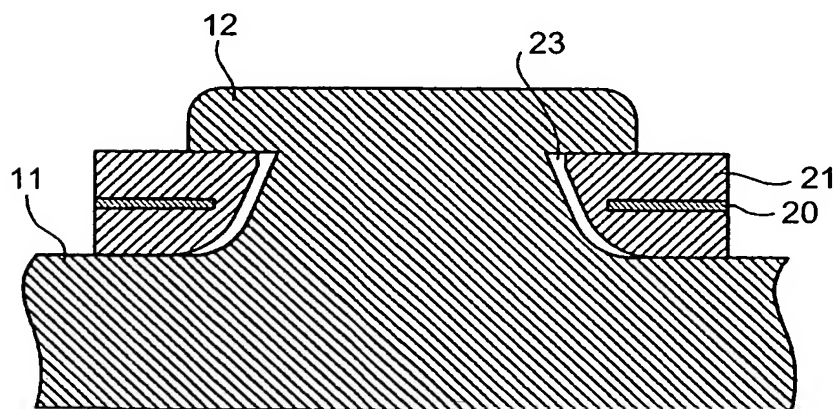


FIG.8

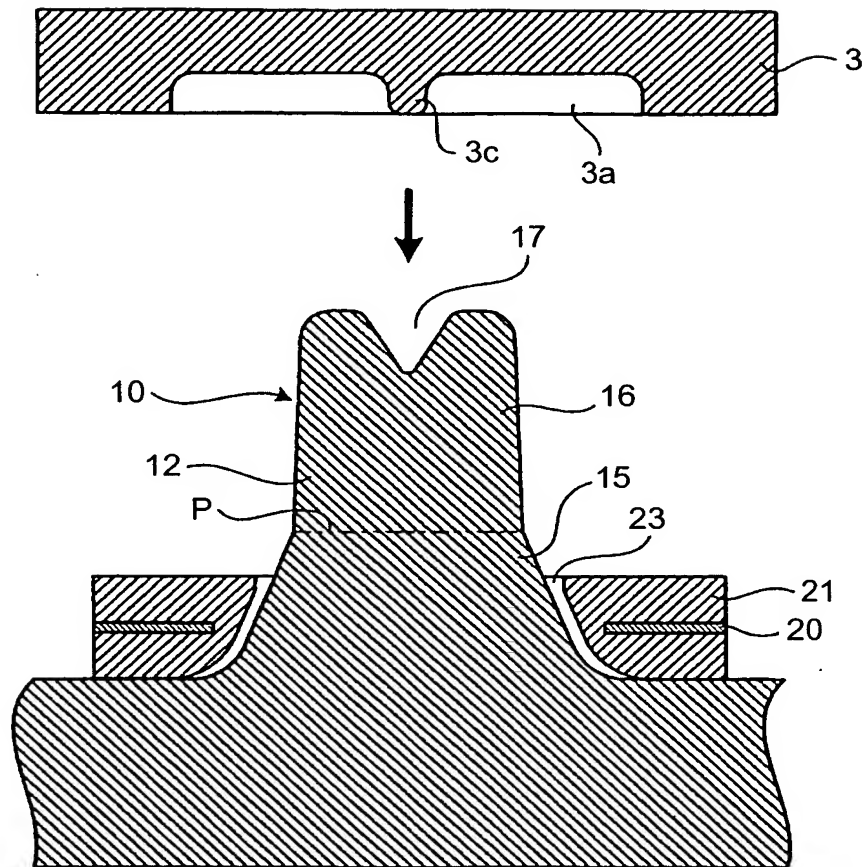


FIG.9

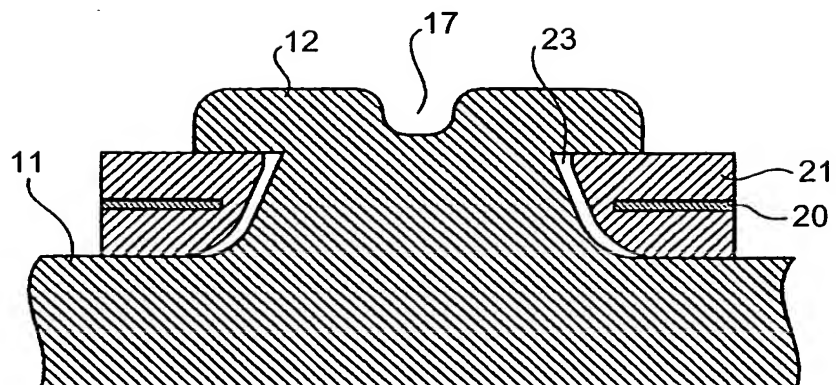


FIG.10

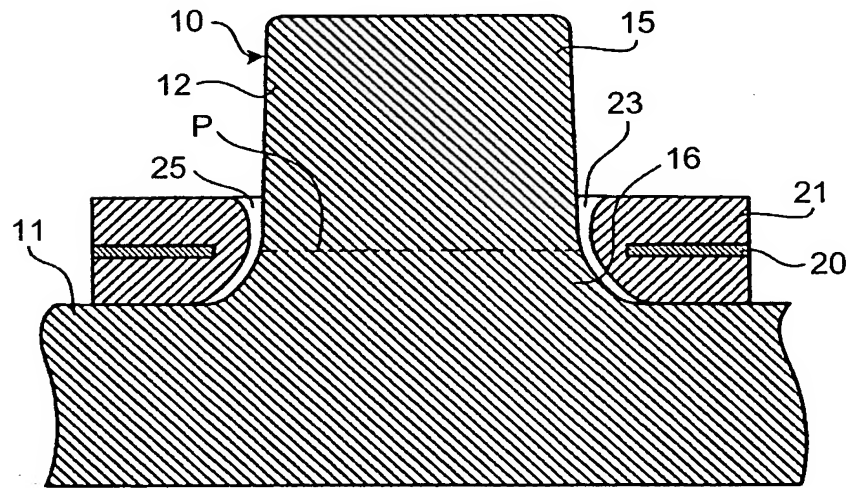
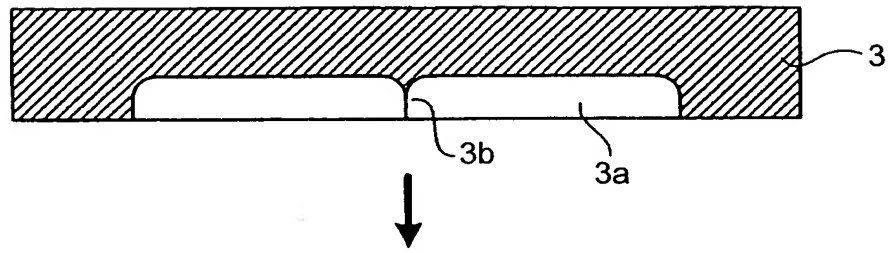


FIG.11

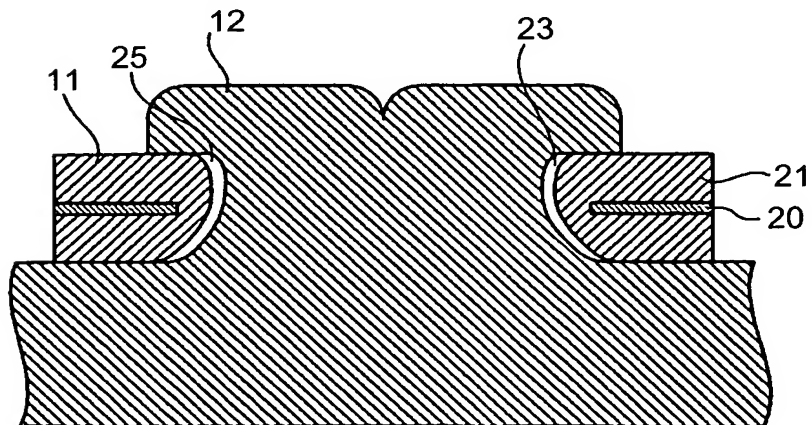


FIG.12

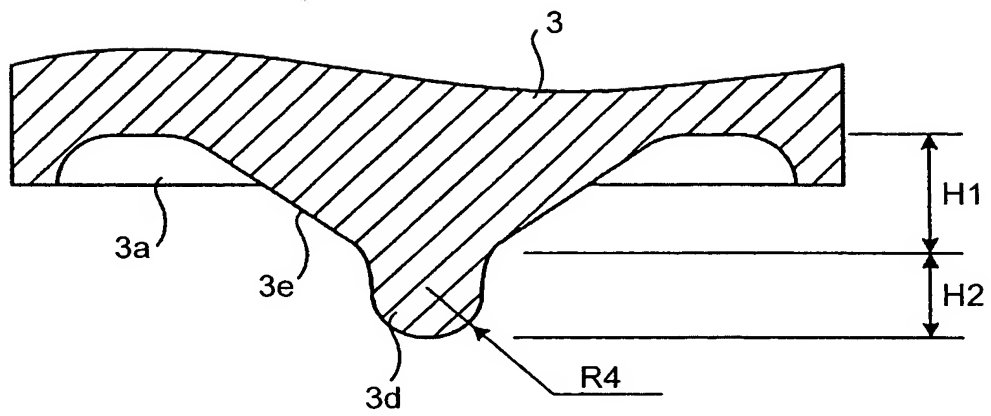




FIG.13

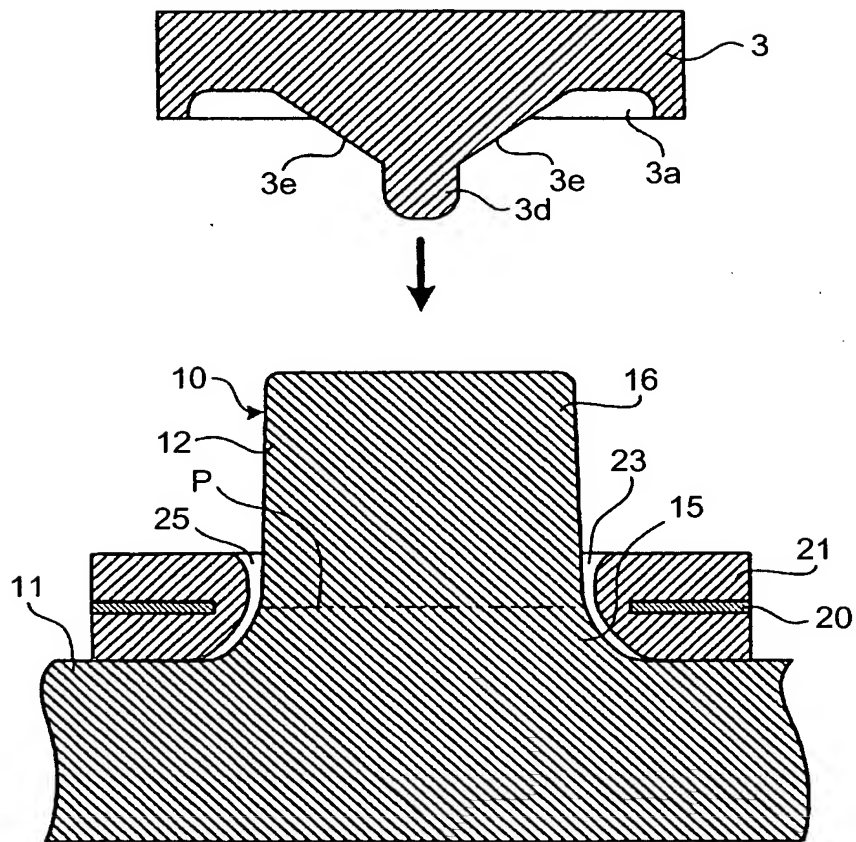


FIG.14

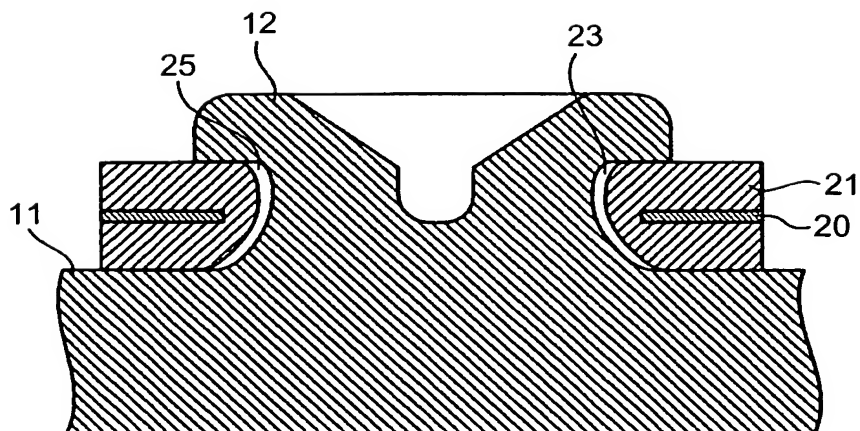


FIG.15

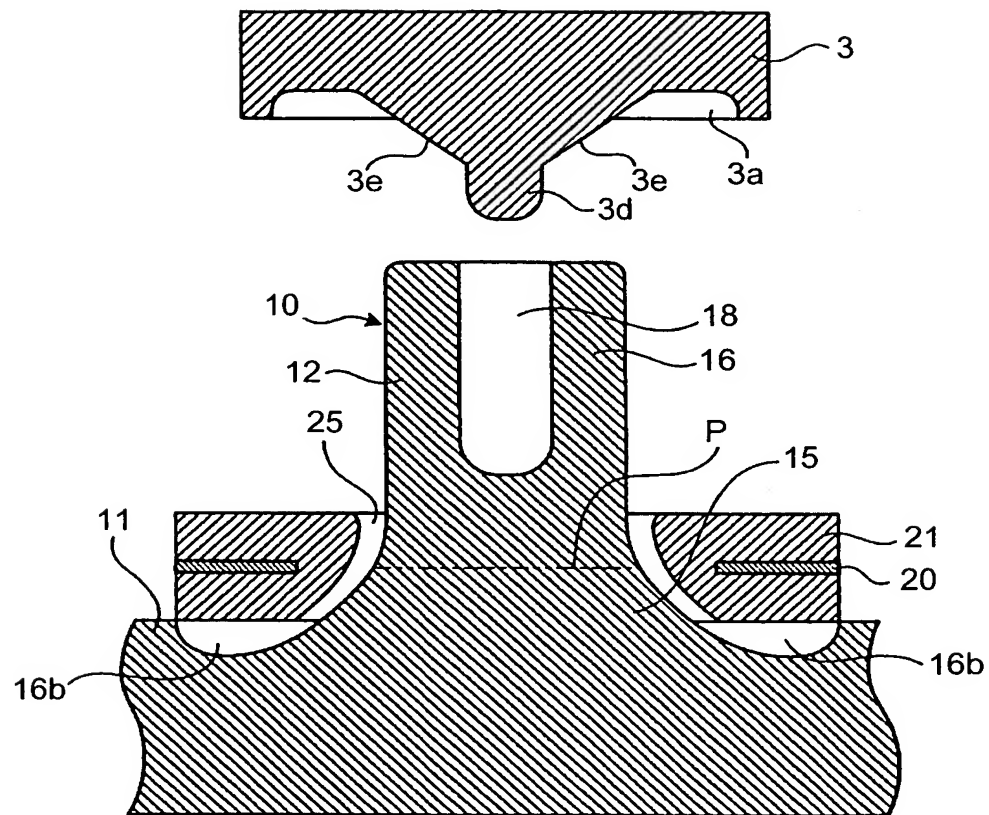
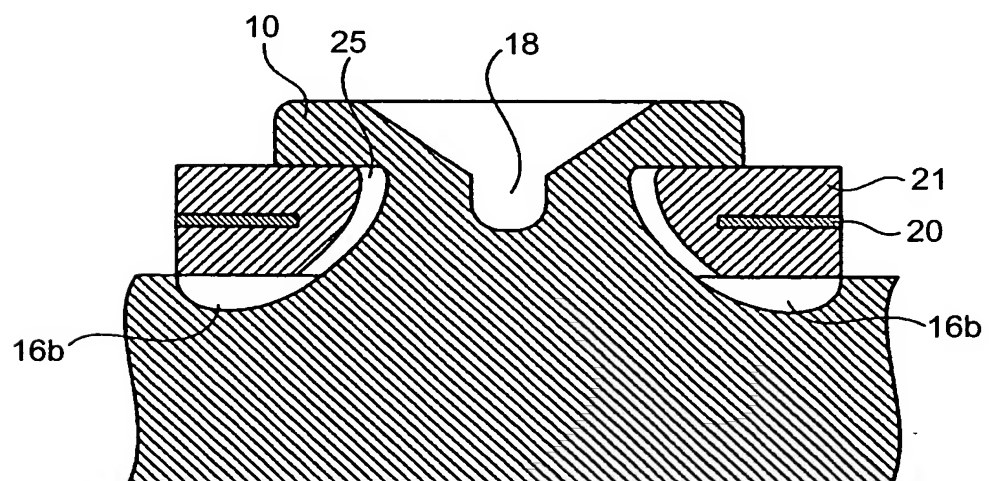


FIG.16



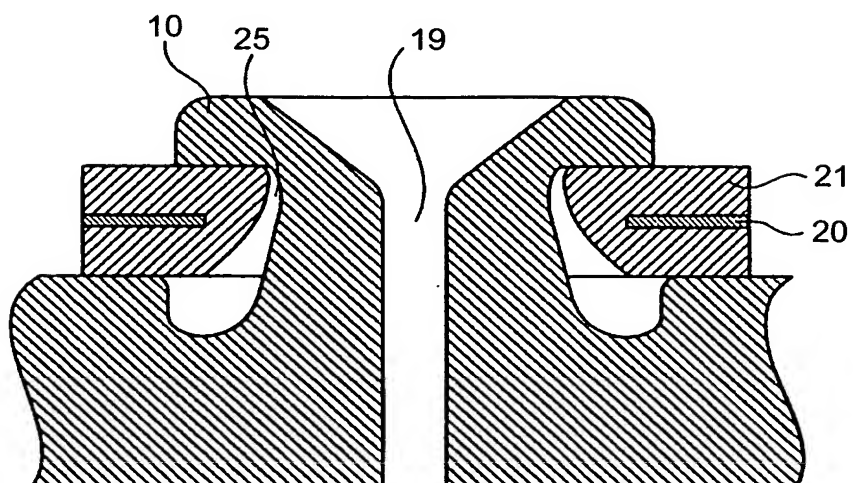


FIG.19

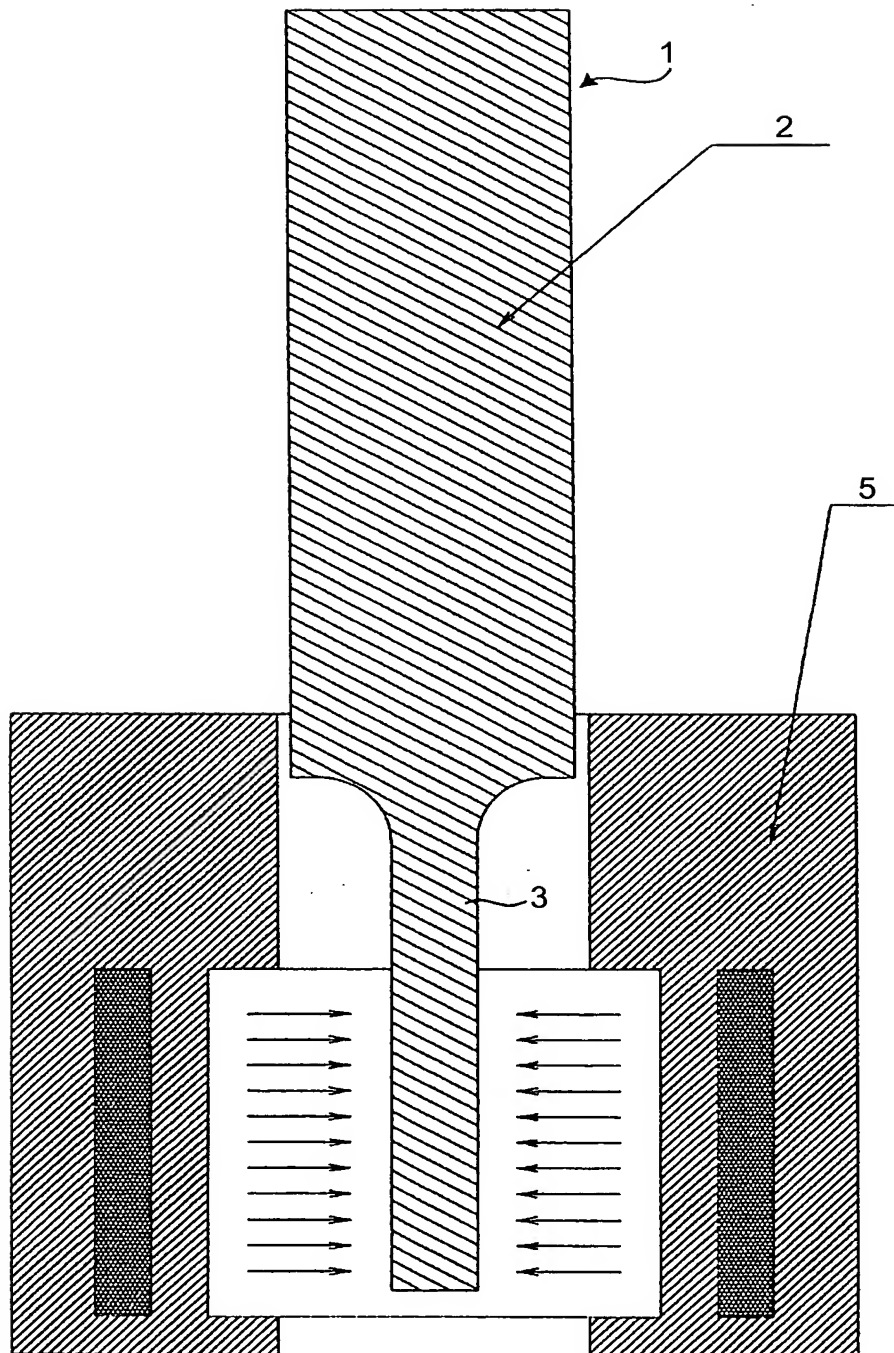


FIG.20

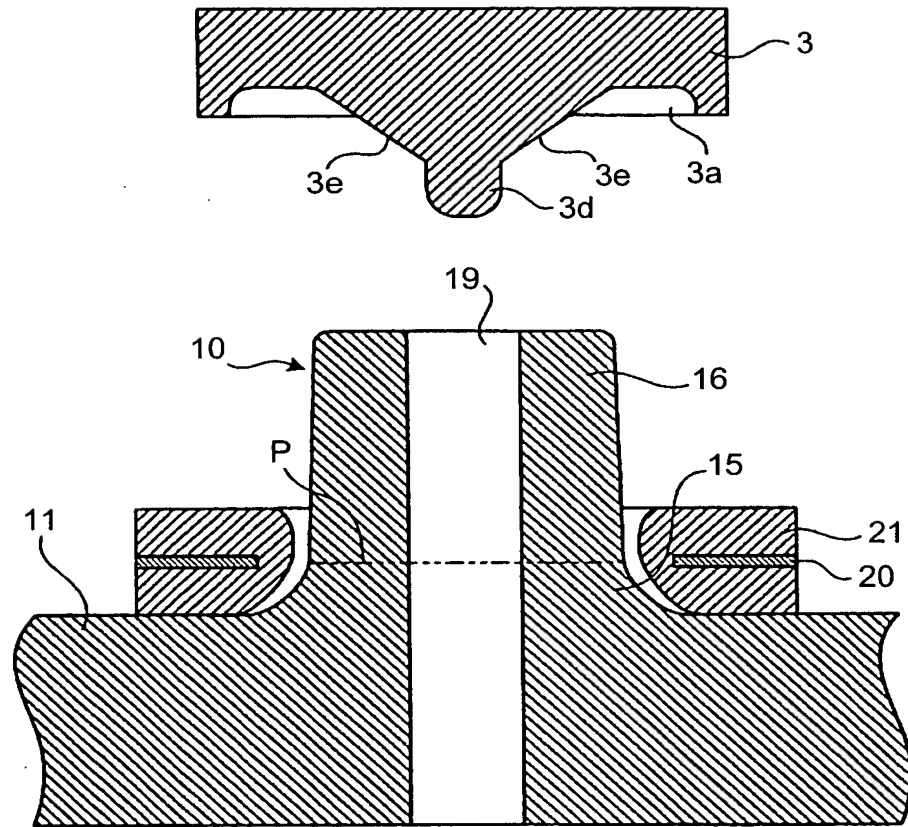


FIG.21

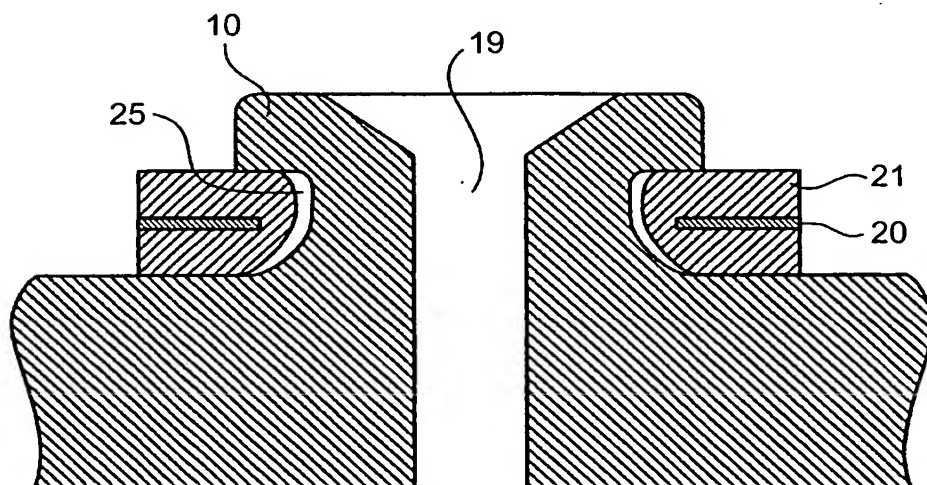


FIG.22

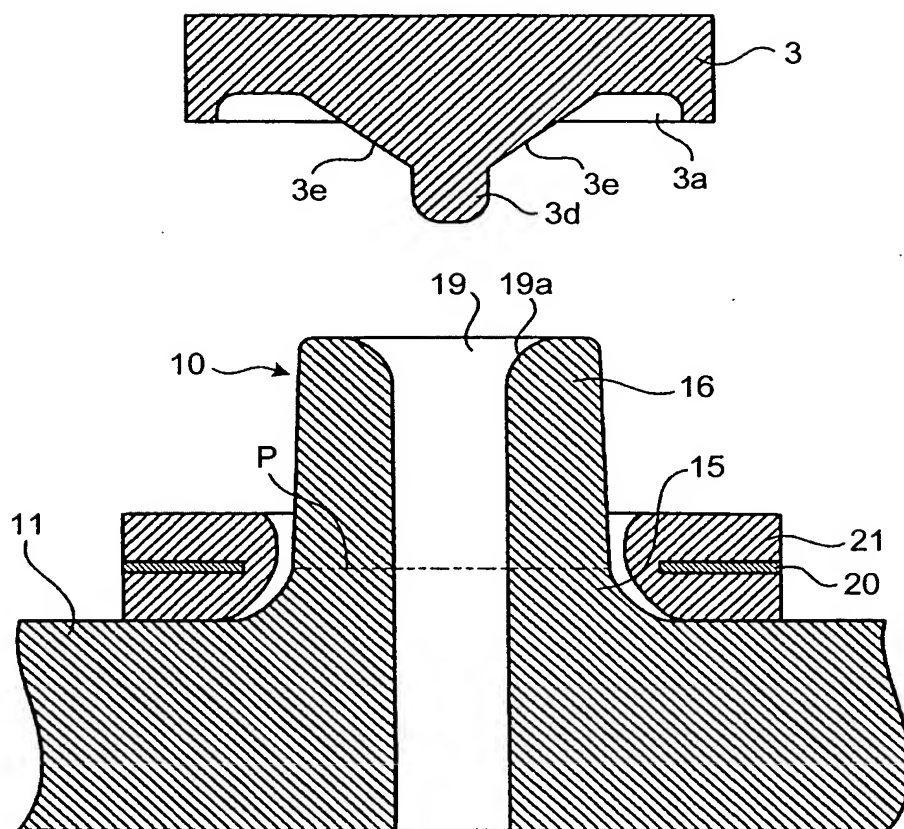


FIG.23

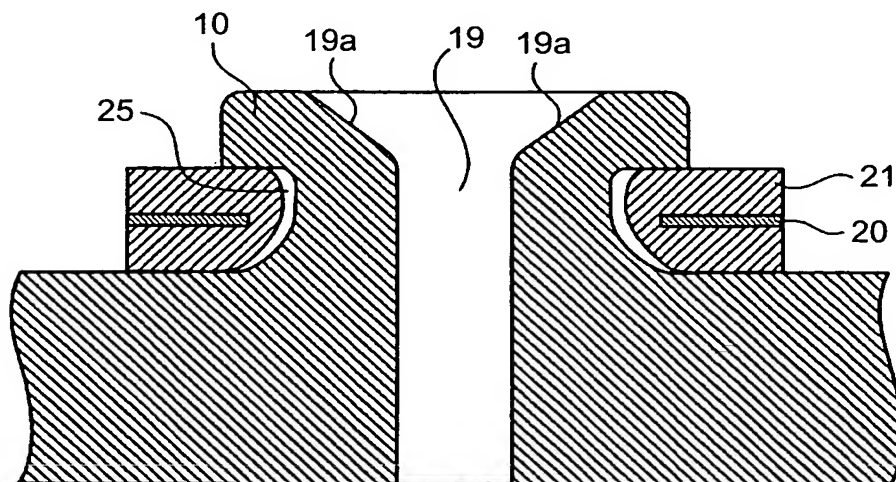


FIG.24

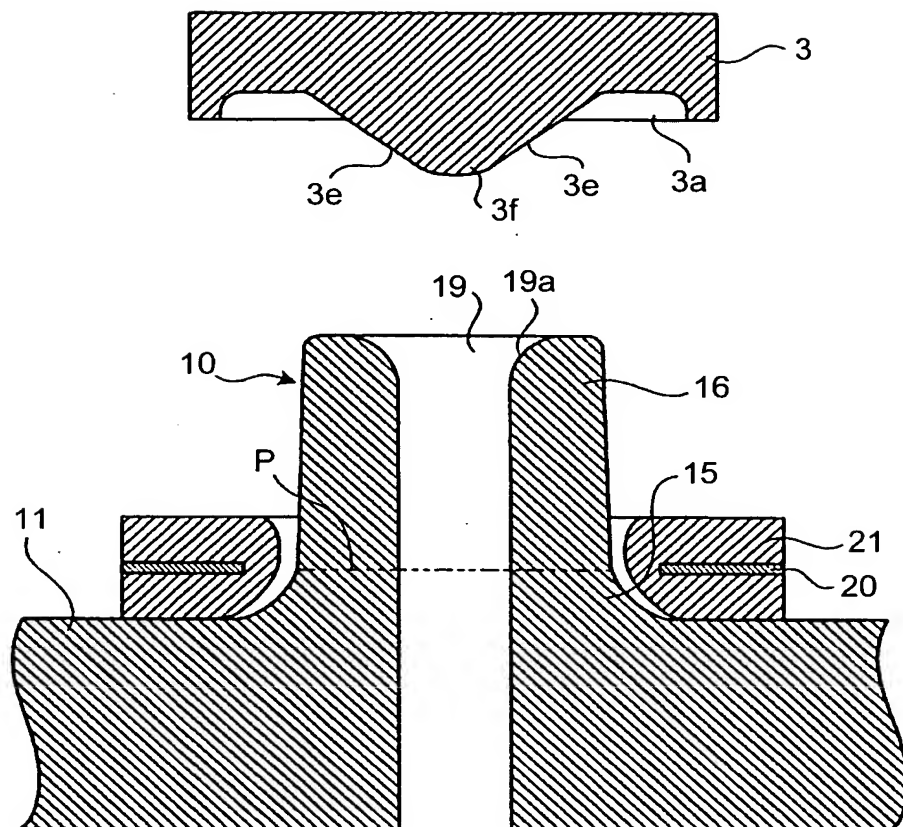


FIG.25

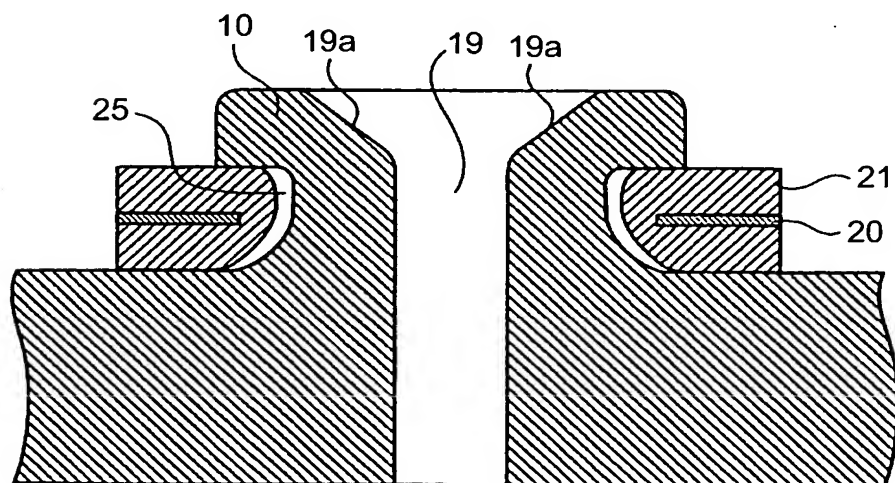


FIG.26

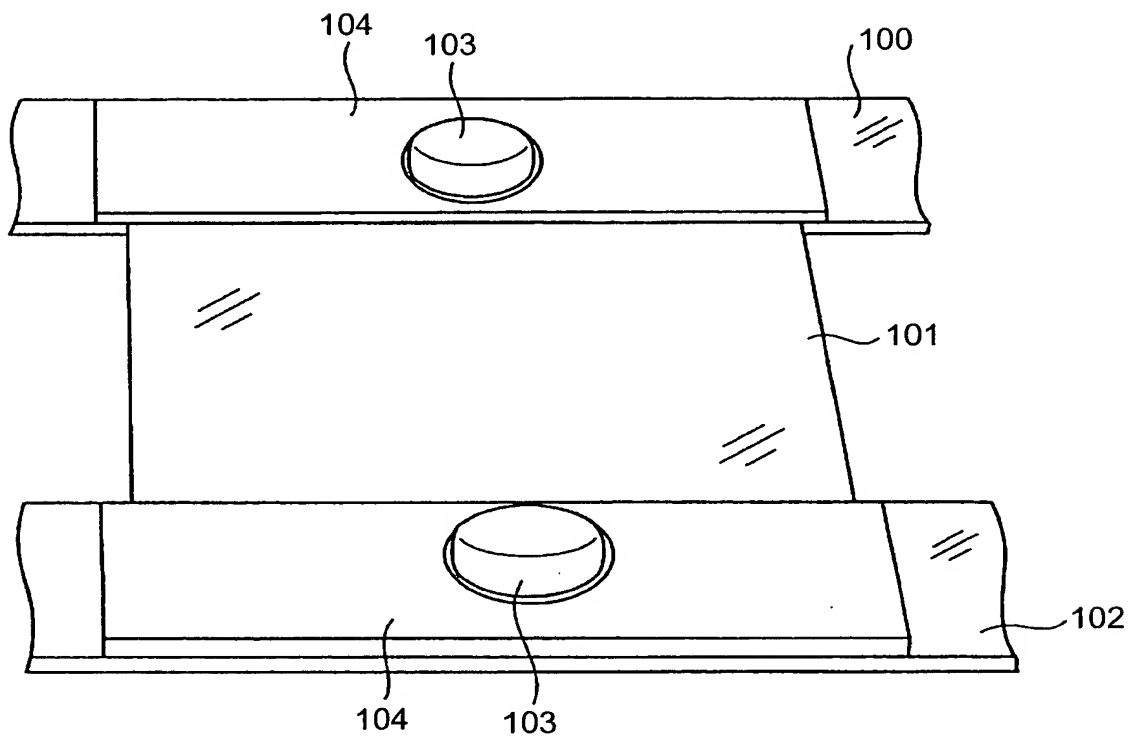




FIG.27

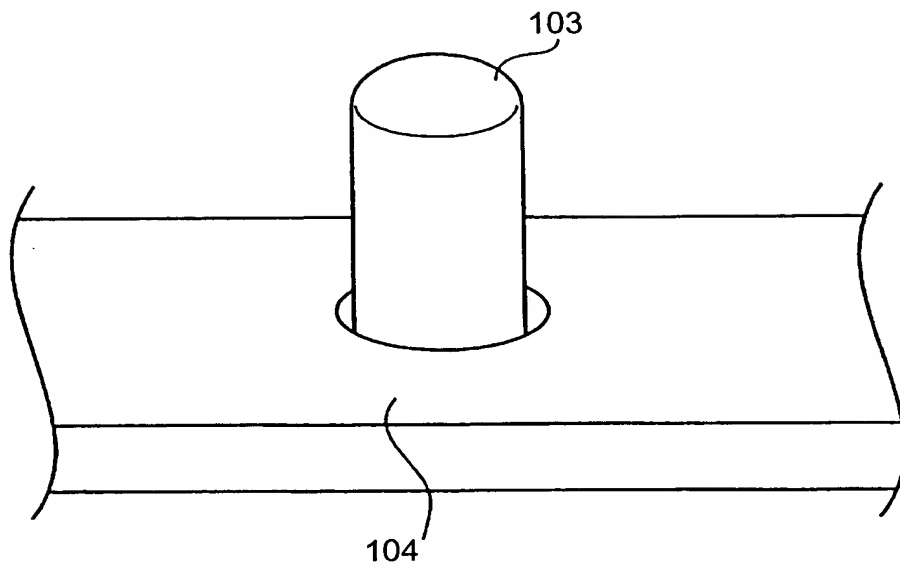


FIG.28

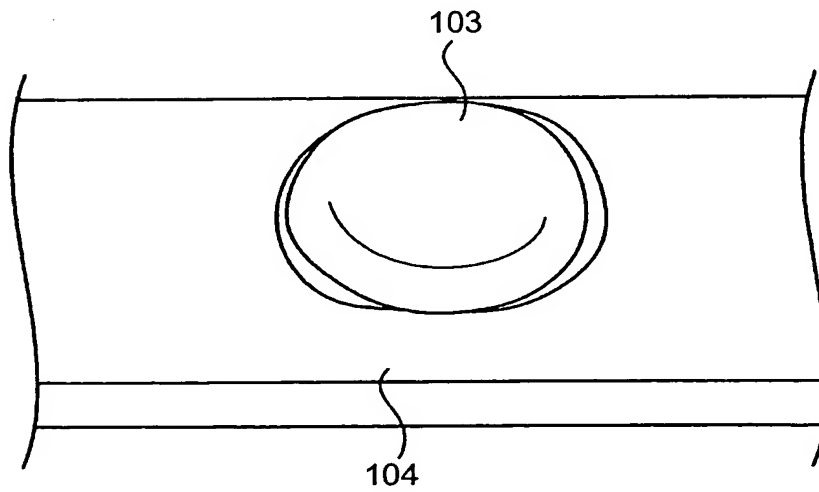


FIG.29

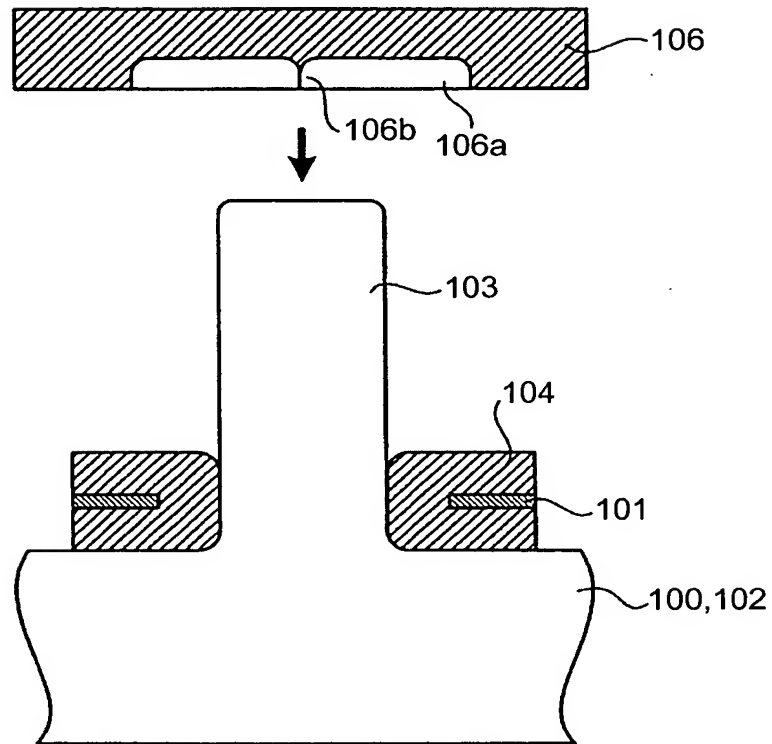


FIG.30

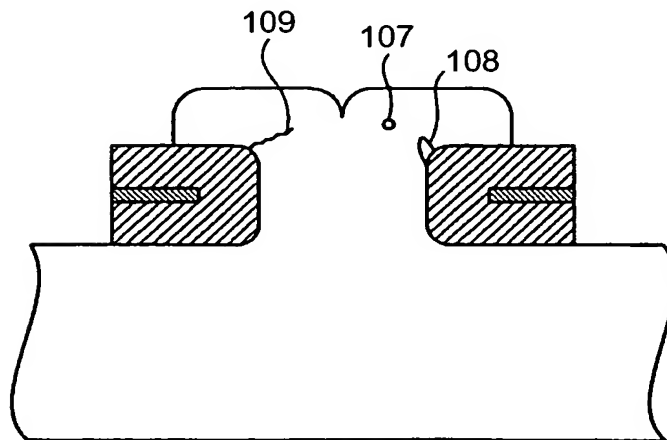
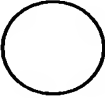
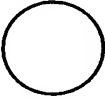
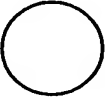


FIG.31

CAUSES PHENOMENA	EXCESSIVE ENERGY APPLIED	EXCESSIVE DEFORMATION OF MOLTEN RESIN	UNFAVORABLE DEFORMATION DIRECTION OF MOLTEN RESIN
VOID			
RIDGE			
CRACK	